

# Work Order ID 84940

**\*84940\***

Page 1

May-29-12 1:11:59 PM

Item ID: D2918-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle RH

Start Date: 29/05/2012 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/30 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2918

Rev B

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS.I

Memo

0.00

HAAS CNC vertical machine #1

Program batch numberMachine Step No 1 as per Folio FA440 and visually inspect as per Dwg D2918 & attached Dimension SheetMachine Step No 2 as per Folio FA440 and visually inspect as per Dwg D2918 & attached Dimension SheetMachine Step No 3 as per Folio

110

0.00

**\*110\***

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per Dwg D2918 & attached dimension sheet

120

0.00

**\*120\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84940

\*84940\*

Page 2

May-29-12 1:11:59 PM

Item ID: D2918-2

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Saddle RH

Stop \*NS2\*

Start Date: 29/05/2012 Start Qty: 30.00

\*30\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 30.00

\*30\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

SL 12-06-11

\*130\*

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

Memo

0.00

Hand Finishing

30 12-06-11

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*150\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

200

30X 12/06/11 M-L

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 84940**

May-29-12 1:11:59 PM

**\*84940\***

Page 3

Item ID: D2918-2

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Saddle RH

Start Date: 29/05/2012 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00				30	0	12-6-11	
Quality Control									
170	Identify as per dwg & Stock Location: <u>922</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

12/6/12  
012-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-29-12 1:12:03 PM

Page 1

Work Order ID: 84940

\*84940\*

Parent Item: D2918-2

\*D2918-2\*

Parent Item Name: Saddle RH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP: A04.07.16New IssueKJ/JLM

IPP B 07.08.07 ECN930 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-011		Manufactured	No			100	Each	66.0000	1	30			

\*D6102-011\*

Saddle Billet

\*\*

ST 12-06-05

Location

Loc Qty

Loc Code

MAT043

6

52068

6

MAT047

60

75834

60

820

x6

x24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	84940
<b>Description:</b> Saddle RH		<b>Part Number:</b>	D2918-2
<b>Inspection Dwg:</b> D2918 <b>Rev.</b> B		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.090	0.110		0.095	0.095	0.095	0.095		
B	0.175	0.205		0.191	0.191	0.190	0.190		
C	0.175	0.217		0.217	0.198	0.198	0.198		
D	R0.470	0.530		0.500	0.500	0.500	0.500		
E	0.740	0.760		0.760	0.760	0.760	0.760		
F	0.277	0.297		0.288	0.286	0.286	0.286		
G	3.170	3.230		3.200	3.200	3.200	3.200		
H	0.180	0.220		0.180	0.180	0.180	0.180		
I	1.599	1.614		1.612	1.611	1.611	1.611		
J	0.250	0.270		0.261	0.260	0.260	0.260		
K	4.436	4.446		4.441	4.441	4.441	4.441		
L	1.498	1.508		1.503	1.503	1.503	1.503		
M	1.278	1.288		1.283	1.283	1.283	1.283		
N	0.053	0.073		0.053	0.053	0.053	0.053		
O	1.103	1.113		1.108	1.108	1.108	1.108		
P	1.225	1.235		1.230	1.230	1.230	1.230		
Q	0.257	0.262		0.259	0.259	0.259	0.259		
R	2.000	2.020		2.001	2.0044	2.0035	2.003		
S	1.385	1.400		1.3863	1.389	1.3885	1.388		
T	0.760	0.765		0.760	0.760	0.760	0.760		
U	0.307	0.312		0.310	0.310	0.309	0.310		
V	0.615	0.635		0.627	0.627	0.627	0.627		
W	0.438	0.443		0.440	0.440	0.440	0.440		
X	0.490	0.510		0.500	0.500	0.499	0.498		
Y	1.745	1.755		1.750	1.750	1.750	1.750		
Z	3.495	3.505		3.500	3.500	3.500	3.500		
AA	7.990	8.010		8.000	8.000	8.000	8.000		
AB	0.023	0.043		0.033	0.033	0.033	0.033		
AC	0.178	0.198		0.188	0.188	0.188	0.188		
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	H.A.
Date:	12/06/07

Audited by:	JL
Date:	12-06-11

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	08.11.27	Added dimension 'AB,AC', Revised Dimension 'R'	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 84940
<b>Description:</b> Saddle RH		<b>Part Number:</b> D2918-2
<b>Inspection Dwg:</b> D2918	<b>Rev.</b> B	<b>Page</b> 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.090	0.110		0.095	0.095	0.095	0.095		
B	0.175	0.205		0.190	0.190	0.190	0.190		
C	0.175	0.217		0.198	0.198	0.198	0.198		
D	R0.470	0.530		0.500	0.500	0.500	0.500		
E	0.740	0.760		0.760	0.760	0.760	0.760		
F	0.277	0.297		0.286	0.286	0.286	0.286		
G	3.170	3.230		3.200	3.200	3.200	3.200		
H	0.180	0.220		0.180	0.180	0.180	0.180		
I	1.599	1.614		1.611	1.611	1.611	1.611		
J	0.250	0.270		0.260	0.260	0.260	0.260		
K	4.436	4.446		4.441	4.441	4.441	4.441		
L	1.498	1.508		1.503	1.503	1.503	1.503		
M	1.278	1.288		1.283	1.283	1.283	1.283		
N	0.053	0.073		0.053	0.053	0.053	0.053		
O	1.103	1.113		1.108	1.108	1.108	1.108		
P	1.225	1.235		1.230	1.230	1.230	1.230		
Q	0.257	0.262		0.259	0.259	0.259	0.259		
R	2.000	2.020		2.003	2.003	2.003	2.003		
S	1.385	1.400		1.388	1.388	1.388	1.388		
T	0.760	0.765		0.760	0.760	0.760	0.760		
U	0.307	0.312		0.310	0.310	0.310	0.310		
V	0.615	0.635		0.627	0.627	0.627	0.627		
W	0.438	0.443		0.440	0.440	0.440	0.440		
X	0.490	0.510		0.500	0.500	0.501	0.501		
Y	1.745	1.755		1.750	1.750	1.750	1.750		
Z	3.495	3.505		3.500	3.500	3.500	3.500		
AA	7.990	8.010		8.000	8.000	8.000	8.000		
AB	0.023	0.043		0.033	0.033	0.033	0.033		
AC	0.178	0.198		0.188	0.188	0.188	0.188		
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: B.A
Date: 12/06/08

Audited by: SL
Date: 12-06-11

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	08.11.27	Added dimension 'AB,AC', Revised Dimension 'R'	KJ/JLM	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	84940
<b>Description:</b> Saddle RH		<b>Part Number:</b>	D2918-2
<b>Inspection Dwg:</b> D2918	<b>Rev.</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	10	11	12	By	Date
A	0.090	0.110		0.095	0.095	0.095	0.095		
B	0.175	0.205		0.190	0.190	0.190	0.190		
C	0.175	0.217		0.198	0.198	0.198	0.198		
D	R0.470	0.530		0.500	0.500	0.500	0.500		
E	0.740	0.760		0.760	0.760	0.760	0.760		
F	0.277	0.297		0.286	0.286	0.286	0.286		
G	3.170	3.230		3.200	3.200	3.200	3.200		
H	0.180	0.220		0.180	0.180	0.180	0.180		
I	1.599	1.614		1.611	1.611	1.611	1.611		
J	0.250	0.270		0.260	0.260	0.260	0.260		
K	4.436	4.446		4.441	4.441	4.441	4.441		
L	1.498	1.508		1.503	1.503	1.503	1.503		
M	1.278	1.288		1.283	1.283	1.283	1.283		
N	0.053	0.073		0.053	0.053	0.053	0.053		
O	1.103	1.113		1.108	1.108	1.108	1.108		
P	1.225	1.235		1.230	1.230	1.230	1.230		
Q	0.257	0.262		0.259	0.259	0.259	0.259		
R	2.000	2.020		2.003	2.003	2.003	2.003		
S	1.385	1.400		1.388	1.388	1.388	1.388		
T	0.760	0.765		0.760	0.760	0.760	0.760		
U	0.307	0.312		0.310	0.310	0.310	0.310		
V	0.615	0.635		0.627	0.627	0.627	0.627		
W	0.438	0.443		0.440	0.440	0.440	0.440		
X	0.490	0.510		0.501	0.502	0.502	0.501		
Y	1.745	1.755		1.750	1.750	1.750	1.750		
Z	3.495	3.505		3.500	3.500	3.500	3.500		
AA	7.990	8.010		8.000	8.000	8.000	8.000		
AB	0.023	0.043		0.033	0.033	0.033	0.033		
AC	0.178	0.198		0.188	0.188	0.188	0.188		
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	B.A.
Date:	12/06/08

Audited by:	JL
Date:	12-06-11

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	08.11.27	Added dimension 'AB,AC', Revised Dimension 'R'	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 84940
<b>Description:</b> Saddle RH		<b>Part Number:</b> D2918-2
<b>Inspection Dwg:</b> D2918	<b>Rev.</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#13	#14	#15	#16	By	Date
A	0.090	0.110		0.100	0.100	.100	.100		
B	0.175	0.205		0.190	0.190	.190	.190		
C	0.175	0.217		0.198	0.198	.198	.198		
D	R0.470	0.530		0.500	0.500	.500	.500		
E	0.740	0.760		0.760	0.760	.760	.760		
F	0.277	0.297		0.286	0.286	.286	.286		
G	3.170	3.230		3.200	3.200	3.200	3.200		
H	0.180	0.220		0.180	0.180	.180	.180		
I	1.599	1.614		1.611	1.611	1.610	1.610		
J	0.250	0.270		0.260	0.260	.260	.260		
K	4.436	4.446		4.441	4.441	4.441	4.441		
L	1.498	1.508		1.503	1.503	1.503	1.503		
M	1.278	1.288		1.283	1.283	1.283	1.283		
N	0.053	0.073		0.053	0.060	.060	.055		
O	1.103	1.113		1.108	1.108	1.108	1.108		
P	1.225	1.235		1.230	1.230	1.230	1.230		
Q	0.257	0.262		0.259	0.259	.260	.260		
R	2.000	2.020		2.003	2.003	2.001	2.001		
S	1.385	1.400		1.388	1.388	1.386	1.386		
T	0.760	0.765		0.760	0.760	.760	.760		
U	0.307	0.312		0.310	0.310	.310	.310		
V	0.615	0.635		0.627	0.627	.625	.625		
W	0.438	0.443		0.440	0.440	.440	.440		
X	0.490	0.510		.500	.500	.500	.500		
Y	1.745	1.755		1.750	1.750	1.750	1.750		
Z	3.495	3.505		3.500	3.500	3.500	3.500		
AA	7.990	8.010		8.000	8.000	8.000	8.000		
AB	0.023	0.043		0.033	0.033	.033	.033		
AC	0.178	0.198		0.188	0.188	.188	.188		
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: H. a. / *AK*  
 Date: 12/06/08 / 12/06/09

Audited by: SL  
 Date: 12-06-11

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	08.11.27	Added dimension 'AB,AC', Revised Dimension 'R'	KJ/JLM <i>AK</i>	<i>AK</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: ☒ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	84940
<b>Description:</b> Saddle RH		<b>Part Number:</b>	D2918-2
<b>Inspection Dwg:</b> D2918	<b>Rev.</b> B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#17	#18	#19	#20	By	Date
A	0.090	0.110		.100	.100	.100	.100		
B	0.175	0.205		.190	.190	.193	.191		
C	0.175	0.217		.188	.197	.196	.197		
D	R0.470	0.530		.500	.500	.500	.500		
E	0.740	0.760		.760	.760	.760	.760		
F	0.277	0.297		.283	.282	.282	.281		
G	3.170	3.230		3.200	3.200	3.200	3.200		
H	0.180	0.220		.180	.180	.180	.180		
I	1.599	1.614		1.610	1.610	1.611	1.610		
J	0.250	0.270		.260	.260	.261	.260		
K	4.436	4.446		4.438	4.438	4.441	4.441		
L	1.498	1.508		1.505	1.505	1.503	1.503		
M	1.278	1.288		1.283	1.283	1.283	1.283		
N	0.053	0.073		.055	.055	.055	.055		
O	1.103	1.113		1.109	1.109	1.108	1.108		
P	1.225	1.235		1.230	1.230	1.230	1.230		
Q	0.257	0.262		.260	.260	.260	.260		
R	2.000	2.020		2.002	2.004	2.007	2.005		
S	1.385	1.400		1.388	1.3895	1.392	1.390		
T	0.760	0.765		.760	.760	.760	.760		
U	0.307	0.312		.310	.310	.310	.310		
V	0.615	0.635		.625	.625	.625	.625		
W	0.438	0.443		.440	.440	.440	.440		
X	0.490	0.510		.500	.500	.500	.500		
Y	1.745	1.755		1.750	1.750	1.750	1.750		
Z	3.495	3.505		3.500	3.500	3.500	3.500		
AA	7.990	8.010		8.000	8.000	8.000	8.000		
AB	0.023	0.043		.033	.033	.033	.033		
AC	0.178	0.198		.188	.188	.188	.188		
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL
Date:	12/06/09

Audited by:	SL
Date:	12-06-11

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	08.11.27	Added dimension 'AB,AC', Revised Dimension 'R'	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	84940
<b>Description:</b> Saddle RH		<b>Part Number:</b>	D2918-2
<b>Inspection Dwg:</b> D2918	<b>Rev.</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				121	122	123	124		
A	0.090	0.110		.100	.100	.100	.100		
B	0.175	0.205		.191	.191	.191	.191		
C	0.175	0.217		.198	.197	.197	.197		
D	R0.470	0.530		.500	.500	.500	.500		
E	0.740	0.760		.760	.760	.760	.760		
F	0.277	0.297		.283	.283	.283	.283		
G	3.170	3.230		3.200	3.200	3.200	3.200		
H	0.180	0.220		.180	.180	.180	.180		
I	1.599	1.614		1.610	1.610	1.610	1.610		
J	0.250	0.270		.260	.260	.260	.260		
K	4.436	4.446		4.441	4.441	4.441	4.441		
L	1.498	1.508		1.503	1.503	1.503	1.503		
M	1.278	1.288		1.283	1.283	1.283	1.283		
N	0.053	0.073		.055	.055	.055	.055		
O	1.103	1.113		1.108	1.108	1.108	1.108		
P	1.225	1.235		1.230	1.230	1.230	1.230		
Q	0.257	0.262		.260	.260	.260	.260		
R	2.000	2.020		2.004	2.005	2.005	2.005		
S	1.385	1.400		1.3895	1.390	1.390	1.390		
T	0.760	0.765		.760	.760	.760	.760		
U	0.307	0.312		.310	.310	.310	.310		
V	0.615	0.635		.625	.625	.625	.625		
W	0.438	0.443		.440	.440	.440	.440		
X	0.490	0.510		.500	.500	.497	.500		
Y	1.745	1.755		1.750	1.750	1.750	1.750		
Z	3.495	3.505		3.500	3.500	3.500	3.500		
AA	7.990	8.010		8.000	8.000	8.000	8.000		
AB	0.023	0.043		.033	.033	.033	.033		
AC	0.178	0.198		.188	.188	.188	.188		
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	amb
Date:	12/06/09

Audited by:	SJ
Date:	12-06-11

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	08.11.27	Added dimension 'AB,AC', Revised Dimension 'R'	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	84940
<b>Description:</b> Saddle RH		<b>Part Number:</b>	D2918-2
<b>Inspection Dwg:</b> D2918	<b>Rev.</b> B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#25	#26	#27	#28		
A	0.090	0.110		.100	.100	.100	.095		
B	0.175	0.205		.191	.190	.190	.190		
C	0.175	0.217		.196	.197	.196	.196		
D	R0.470	0.530		.500	.500	.500	.500		
E	0.740	0.760		.760	.760	.760	.760		
F	0.277	0.297		.283	.283	.282	.283		
G	3.170	3.230		3.200	3.200	3.200	3.200		
H	0.180	0.220		.180	.180	.180	.180		
I	1.599	1.614		1.610	1.610	1.609	1.609		
J	0.250	0.270		.260	.260	.260	.260		
K	4.436	4.446		4.441	4.441	4.441	4.441		
L	1.498	1.508		1.503	1.503	1.503	1.503		
M	1.278	1.288		1.283	1.283	1.283	1.283		
N	0.053	0.073		.055	.055	.055	.055		
O	1.103	1.113		1.108	1.108	1.108	1.108		
P	1.225	1.235		1.230	1.230	1.230	1.230		
Q	0.257	0.262		.260	.260	.260	.260		
R	2.000	2.020		2.005	2.005	2.004	2.003		
S	1.385	1.400		1.3905	1.390	1.389	1.389		
T	0.760	0.765		.760	.760	.760	.760		
U	0.307	0.312		.310	.310	.310	.310		
V	0.615	0.635		.635	.635	.635	.635		
W	0.438	0.443		.440	.440	.440	.440		
X	0.490	0.510		.500	.500	.500	.498		
Y	1.745	1.755		1.750	1.750	1.750	1.750		
Z	3.495	3.505		3.500	3.500	3.500	3.500		
AA	7.990	8.010		8.000	8.000	8.000	8.000		
AB	0.023	0.043		.033	.033	.033	.033		
AC	0.178	0.198		.188	.188	.188	.188		
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SMK
Date:	12/06/09

Audited by:	SL
Date:	12-06-11

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	08.11.27	Added dimension 'AB,AC', Revised Dimension 'R'	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24940
<b>Description:</b> Saddle RH		<b>Part Number:</b>	D2918-2
<b>Inspection Dwg:</b> D2918	<b>Rev.</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#29	#30	✓	✓	By	Date
A	0.090	0.110		.095	.095				
B	0.175	0.205		.190	.190				
C	0.175	0.217		.197	.197				
D	R0.470	0.530		.500	.500				
E	0.740	0.760		.760	.760				
F	0.277	0.297		.284	.286				
G	3.170	3.230		3.200	3.200				
H	0.180	0.220		.180	.180				
I	1.599	1.614		1.609	1.610				
J	0.250	0.270		.260	.260				
K	4.436	4.446		4.441	4.441				
L	1.498	1.508		1.503	1.503				
M	1.278	1.288		1.283	1.283				
N	0.053	0.073		.055	.055				
O	1.103	1.113		1.108	1.108				
P	1.225	1.235		1.230	1.230				
Q	0.257	0.262		.260	.260				
R	2.000	2.020		2.002	2.002				
S	1.385	1.400		1.387	1.387				
T	0.760	0.765		.760	.760				
U	0.307	0.312		.310	.310				
V	0.615	0.635		.635	.635				
W	0.438	0.443		.440	.440				
X	0.490	0.510		.499	.500				
Y	1.745	1.755		1.750	1.750				
Z	3.495	3.505		3.500	3.500				
AA	7.990	8.010		8.000	8.000				
AB	0.023	0.043		.033	.033				
AC	0.178	0.198		.188	.188				
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	12/06/09

Audited by:	<i>[Signature]</i>
Date:	12-06-11

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	08.11.27	Added dimension 'AB,AC', Revised Dimension 'R'	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

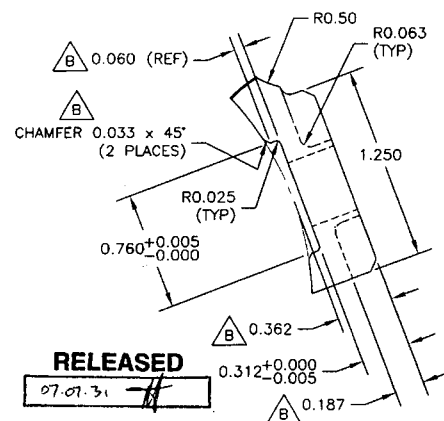




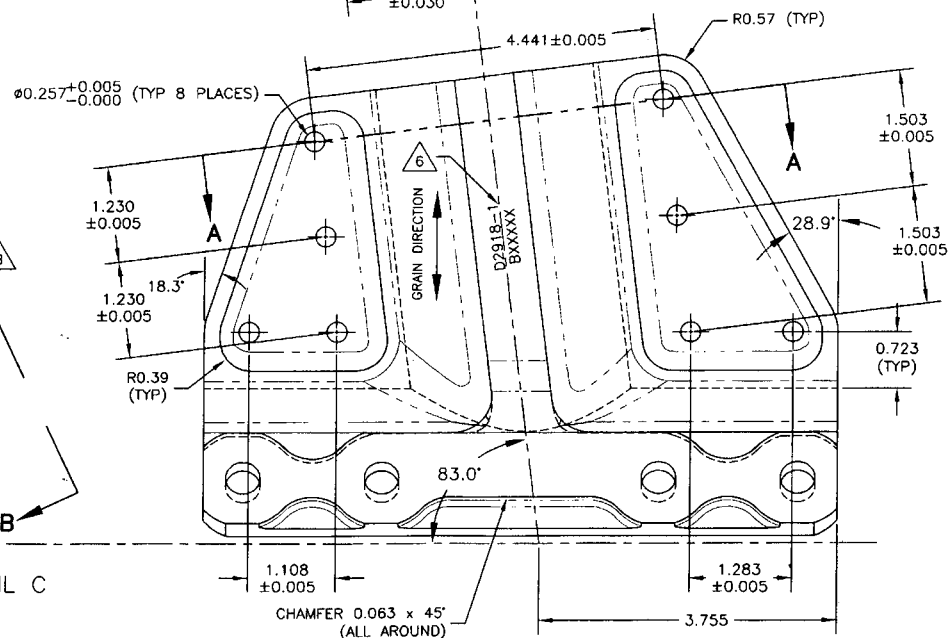
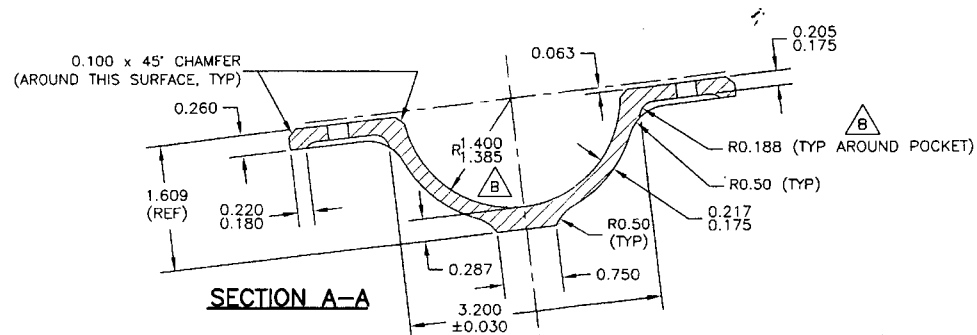
D2918-1 LH SADDLE (SHOWN)  
D2918-2 RH SADDLE (OPPOSITE)






NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
3) BREAK ALL SHARP EDGES 0.010 TO 0.020  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.  
5) ALL DIMENSIONS ARE IN INCHES  
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  
7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



**DETAIL C**   
SCALE 4:3



B	07.02.19	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES	
A	04.05.31	NEW ISSUE	
DESIGN		DRAWN BY	
CHECKED		APPROVED	
DATE		TITLE	
07.02.19		SADDLE	
		 <b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO. D2918- REV. E SHEET 1 OF 2	

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DART AEROSPACE LTD.

**DART** DART AEROSPACE LTD.  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2918-	REV. E
	SHEET 1 OF
TITLE SADDLE	SCALE

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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

WORK ORDER  
NO. 24940 MJS  
12/05/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries